

Date: Thursday, 19/03/2009 4:31:18 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 46623	
Estimate Number : 13459	
P.O. Number :	Part Number : D38051
This Issue : 19/03/2009 S.O. No. :	Drawing Number : D3805 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 46397	Material :
Written By :	Due Date : 31/03/2009 Qty: 2 Um: Each
Checked & Approved By : <u>Julie Dawson 19/03/09</u>	
Comment :	
Est Rev:A 08-07-15 new issue DD verified by:EC	
Est Rev:B 08-07-30 redesign flat pattern DD verified by:EC	
Est Rev:C 08-09-23 redesign flat pattern DD verified by:EC	
Est Rev:D 09-03-04 rev.a as per dwg DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S18GA	304/316 .050 Sheet
-----	-----------	--------------------



Comment: Qty.: 2.0110 sf(s)/Unit Total : 4.0219 sf(s)
 304/316 .050 Sheet
 batch: 108156

ml 09 03 25 (2)

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3805
 Dwg Rev: A
 Prog Rev: A

2-Deburr if necessary

ml 09 03 25 (2)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

ml 09 03 25 (2)

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

S 02/03/25 (2)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE
 Form as per Dwg D3805 using Jigs DT8261 and DT8326

SP 29/03/31 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 19/03/2009 4:31:18 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 46623

Part Number: D38051

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/03/31 (x2)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Eric C-

28 09/03/31 (x2)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/01
MF
09-03-31

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

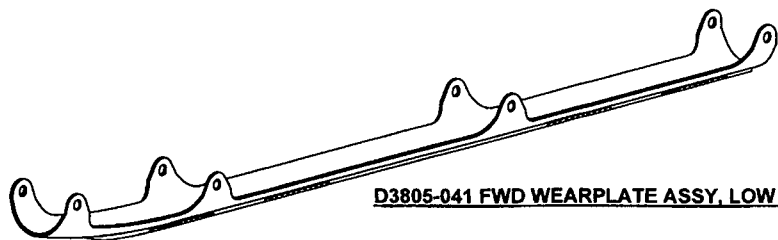
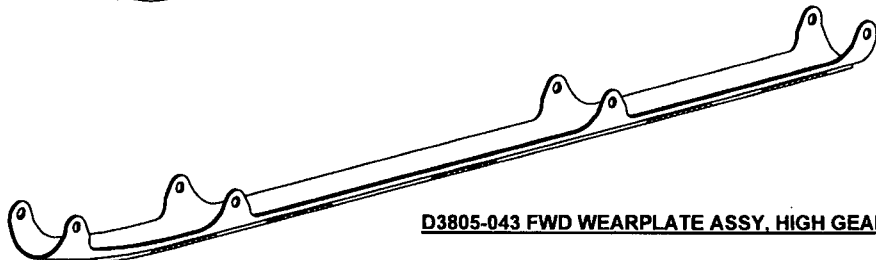
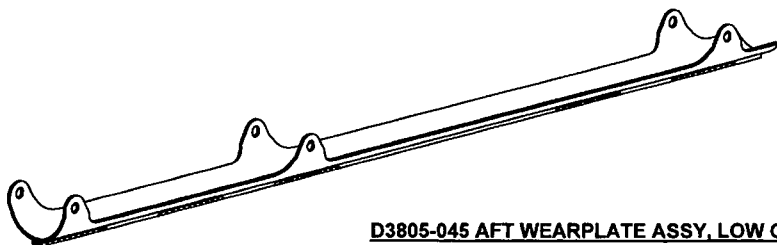
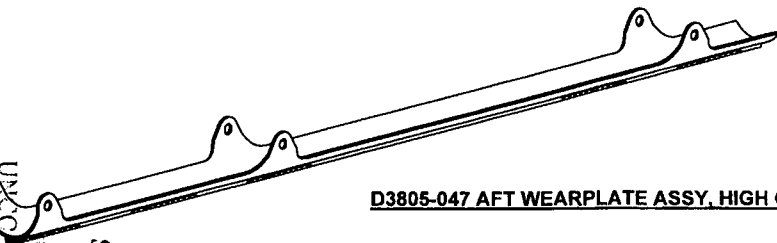
5

4

3

2

1

**D3805-041 FWD WEARPLATE ASSY, LOW GEAR****D3805-043 FWD WEARPLATE ASSY, HIGH GEAR****D3805-045 AFT WEARPLATE ASSY, LOW GEAR****D3805-047 AFT WEARPLATE ASSY, HIGH GEAR**

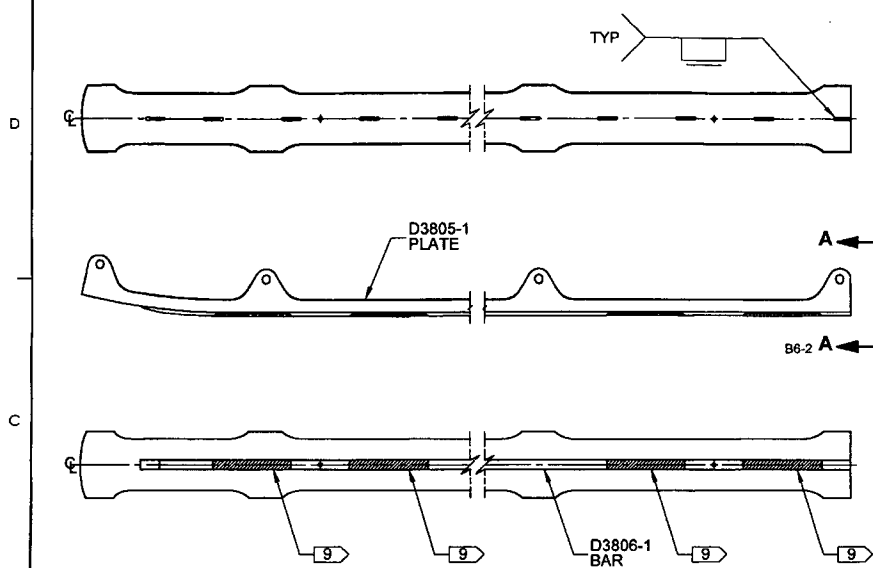
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1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

RELEASED
 47 07.03.03
 Pw ECN 09-538

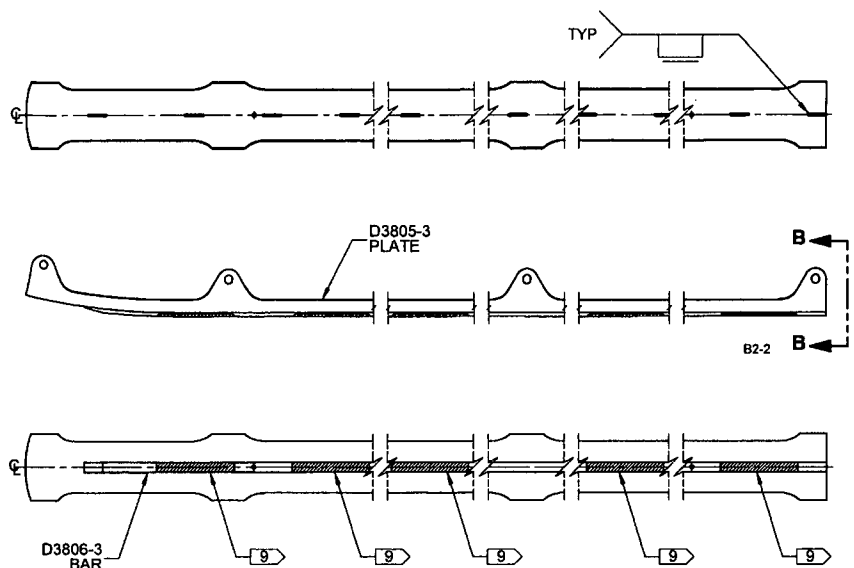
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REV.	DESCRIPTION	BY	DATE
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DRAWN	JS		
CHECKED	JS	DRAWING NO.	REV. A
MFG. APPR.	JS	D3805	SHEET 1 OF 8
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	WEARPLATE ASSY	NTS
DATE	08.11.21	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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8 7 6 5 4 3 2 1



D3805-041 FWD WEARPLATE ASSY, LOW GEAR



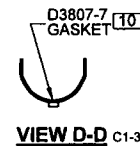
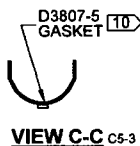
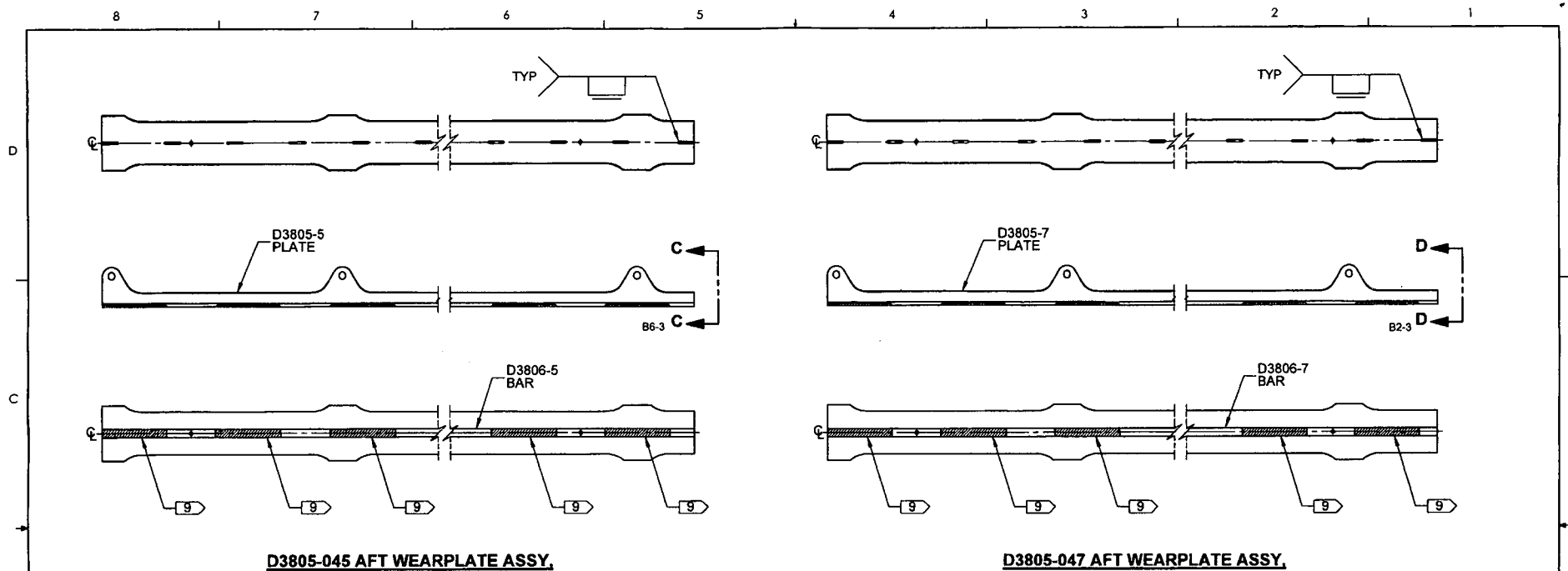
D3805-043 FWD WEARPLATE ASSY, HIGH GEAR

RELEASED
09.03.07

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3805-041 = 3.79 lbs; D3805-043 = 4.36 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2059B HARD COAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
 - 10) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

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Handwritten notes and signatures in the bottom left corner, including a large signature and the word 'COPY' repeated vertically.



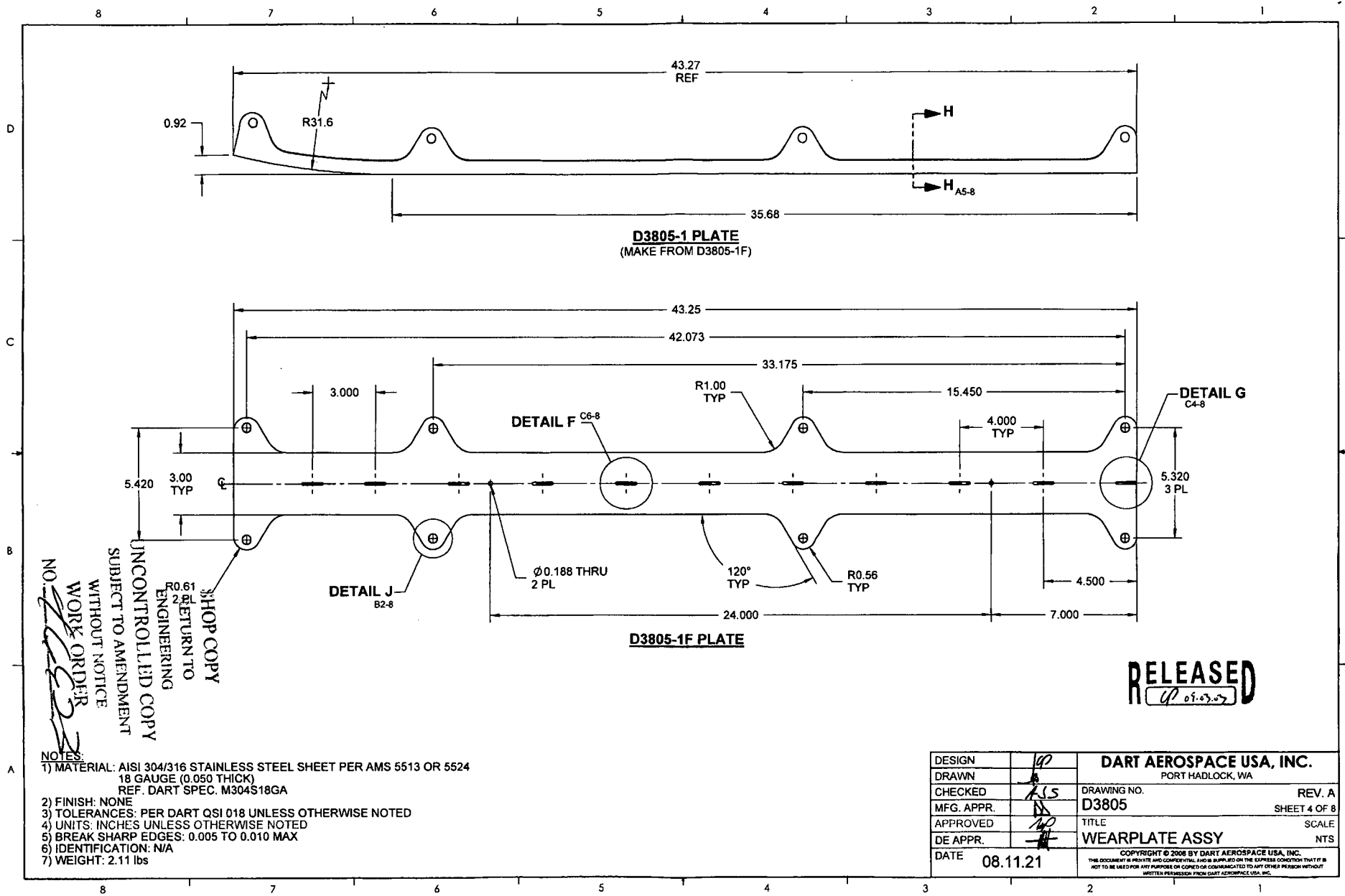
RELEASED
4P 09.03.07

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3805-045 = 3.93 lbs; D3805-047 = 4.21 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

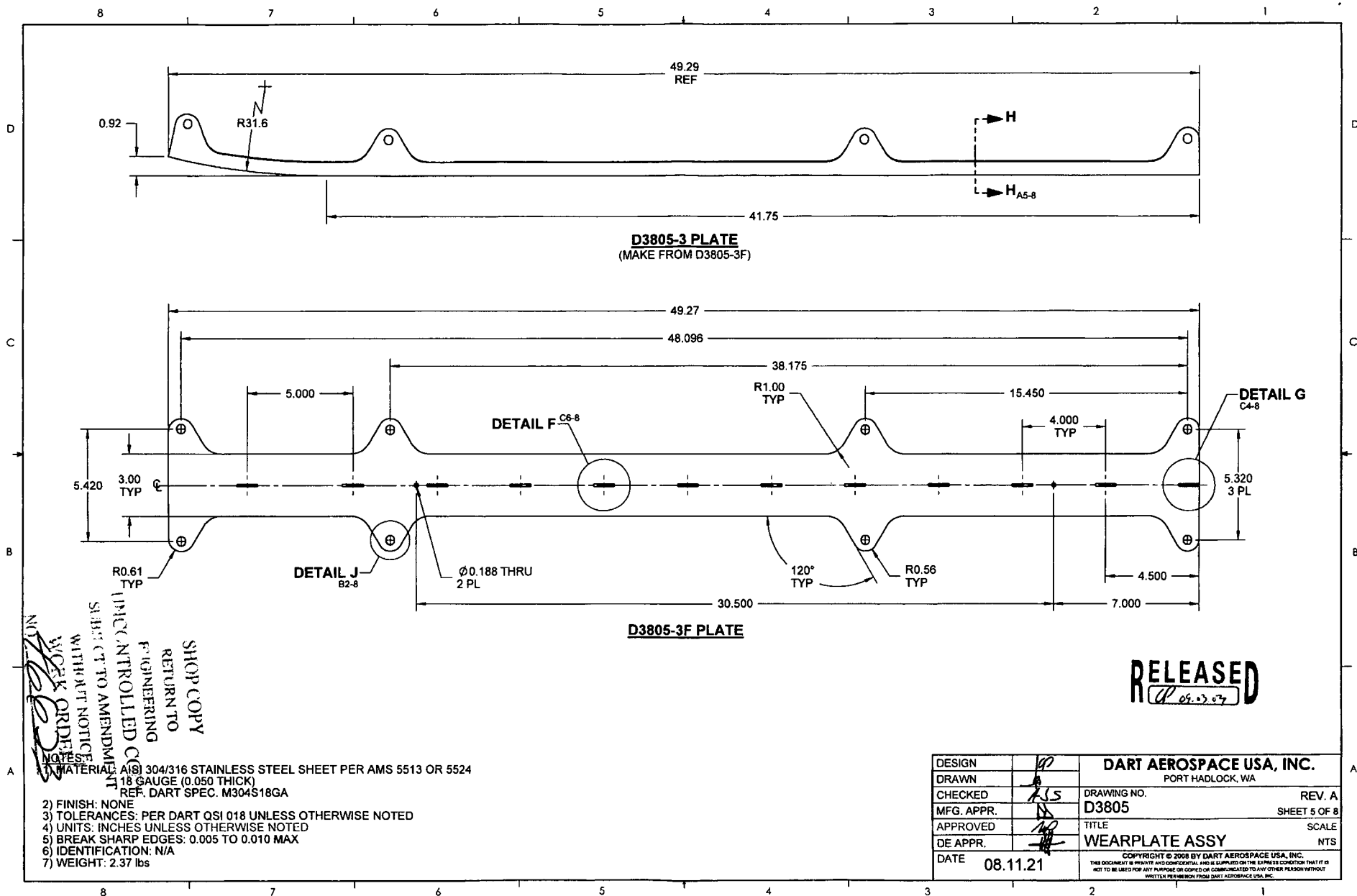
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CHECKED	4P	DRAWING NO. D3805	REV. A
MFG. APPR.	4P	SHEET 3 OF 8	
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DE APPR.	4P	WEARPLATE ASSY	NTS
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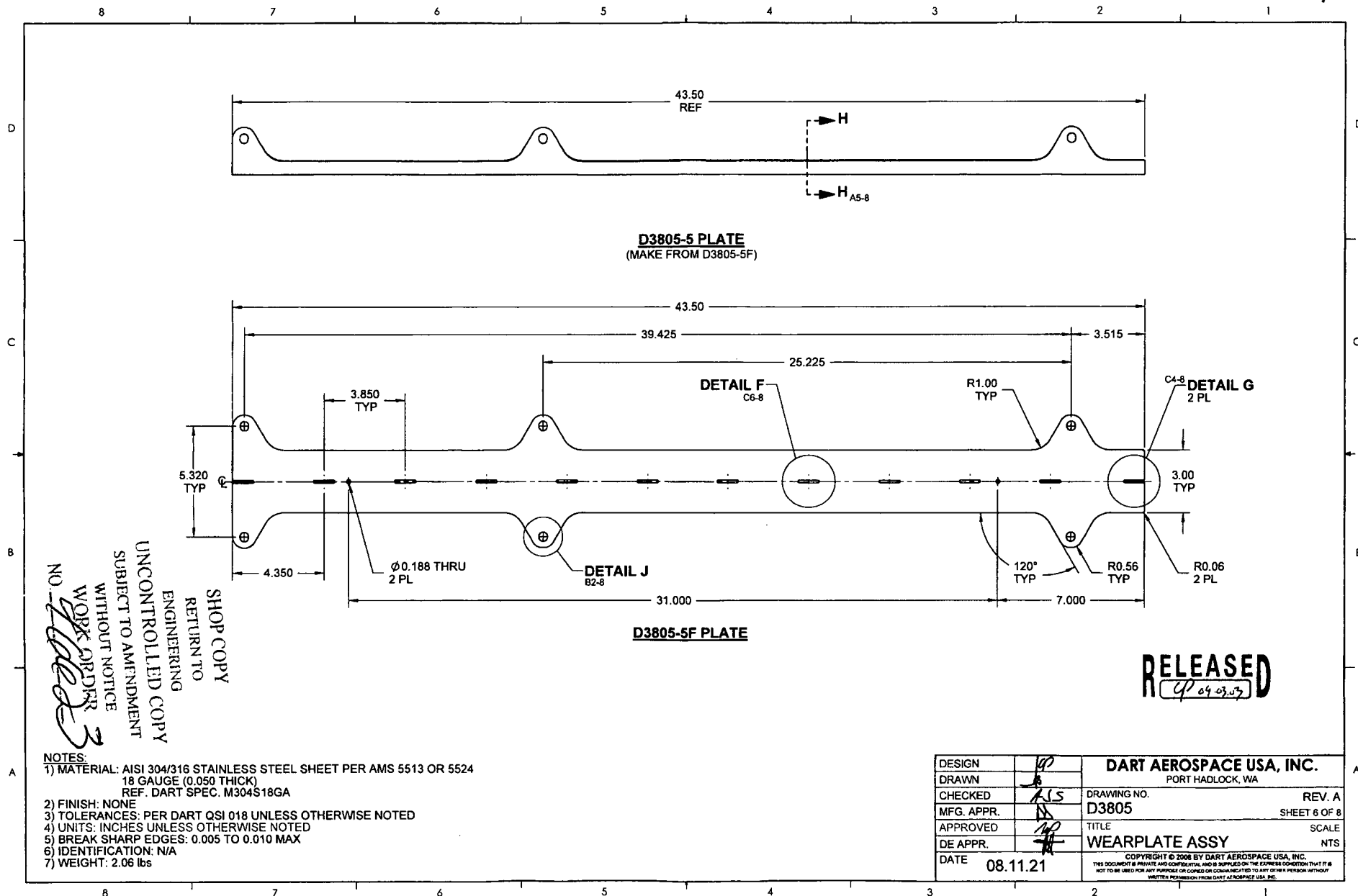
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- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.11 lbs

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MFG. APPR.	15	D3805	SHEET 4 OF 8
APPROVED	15	TITLE	SCALE
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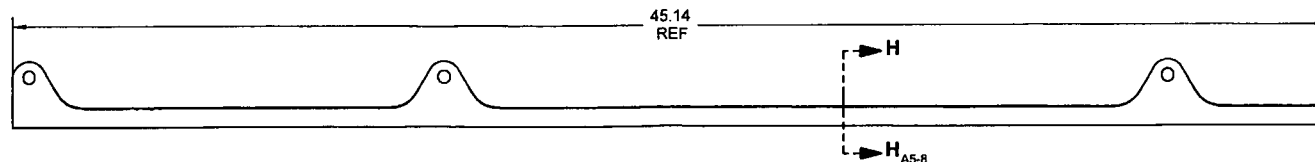
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.06 lbs

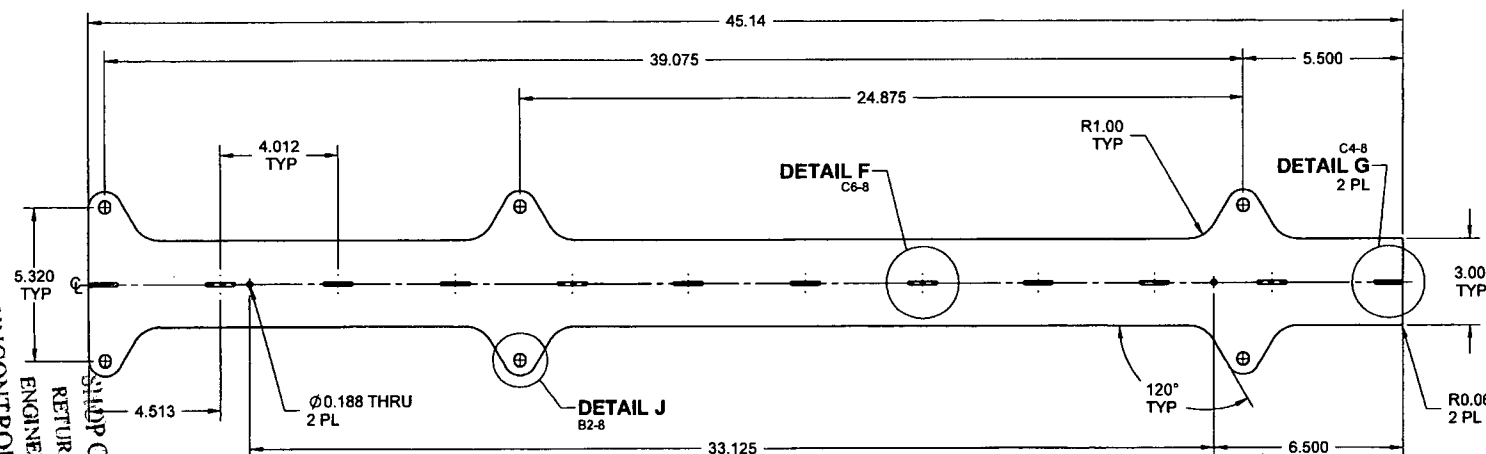
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DRAWN	<i>[Signature]</i>	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3805	SHEET 6 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2 1



D3805-7 PLATE
(MAKE FROM D3805-7F)







D3805-7F PLATE

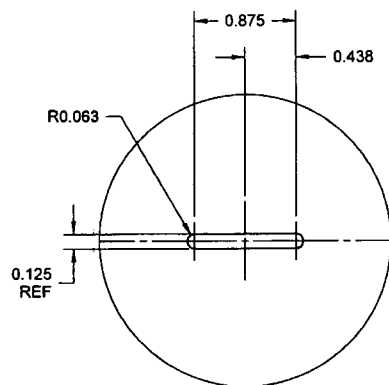
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40 04.03.03

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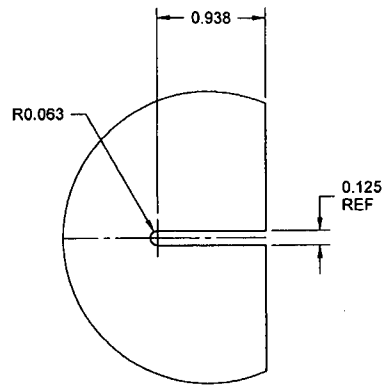
- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.13 lbs

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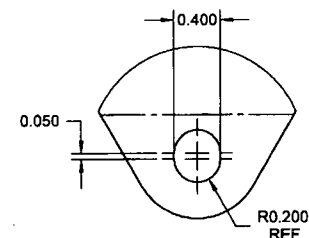
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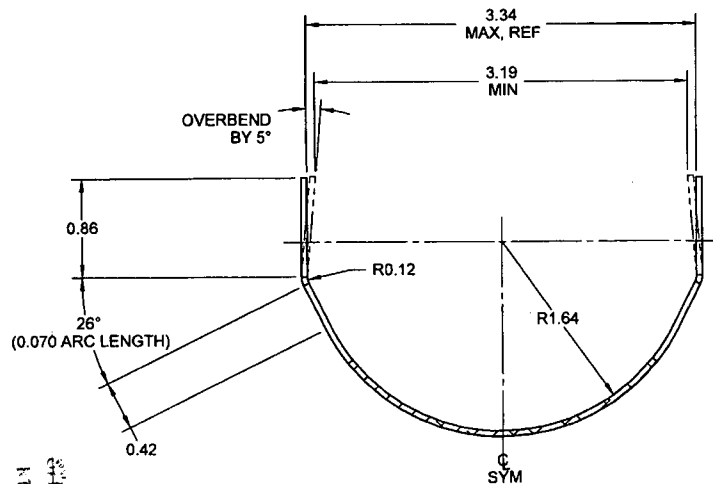
DETAIL F
SLOT DETAIL TYP
SCALE 4X
C5-4
C5-5
C4-6
C4-7



DETAIL G
SLOT DETAIL TYP
SCALE 4X
C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X
B5-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X
D3-4
D3-5
D3-6
D3-7

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4709.09.03

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MFG. APPR.	197	D3805	SHEET 8 OF 8
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DE APPR.	197	WEARPLATE ASSY	NTS
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